

Work Order ID 62165

Page 1

Monday, September 20, 2010 10:10:18 AM

Item ID: D3684-049

Accept



Setup Start



Revision ID:

Item Name: AFT LEG ASS'Y

Stop



Start Date: 9/20/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/1/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-9-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3684	Rev D	
100	Pick Kit	0.00
Packaging	Memo	0.00
Packaging		

110	Small Fab	0.00
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	Memo	0.00
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684	

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fasteners as per Dwg D3684

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SB 10/09/21

(2)

130



Packaging

Packaging

Identify as per dwg & Stock Location: GA

0.00

SB 10/09/21

(2)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

M/F

10-9-21

Memo

0.00



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Picklist Print

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Work Order ID: 62165



Parent Item: D3684-049



Parent Item Name: AFT LEG ASS'Y

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A new issue 08-02-12 DD verified by:JLM
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A		Purchased		No		110	Each	86.0000	2	4		E/S 0/09/20	
Bolts													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST351			86						
				112314			8						
				114761			11						
				115392			47						
				115594			20						
D3688-3		Manufactured		No		110	Each	8.0000	1	2		E/S 0/09/20	
STUD													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST076			5						
				61371			5						
				ST080			3						
				51297			3						
D3689-1		Manufactured		No		110	Each	13.0000	1	2		E/S 0/09/20	
SLEEVE													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST082			13						
				56335			1						
				58634			12						

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Parent Item: D3684-049



Parent Item Name: AFT LEG ASS'Y

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 2.00

Required Qty: 2.00

D3691-1



Manufactured

No

110

Each

15.0000

1

2

EJ 10/09/20

STUD

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST082	15	
58631	15	

D3692-1



Manufactured

No

110

Each

349.0000

4

8

EJ 10/09/20

D3693-1



Rod End Bearing

Manufactured

No

110

Each

40.0000

1

2

EJ 10/09/20

MS21043-3



Nut

Purchased

No

110

Each

2,643.000

2

4

EJ 10/09/20

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	76	
103691	76	
ST301	2567	
109147	4	
111383	46	
112314	2517	

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Parent Item Name: AFT LEG ASS'Y

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 2.00

Required Qty: 2.00

NAS509-12C



Purchased

No

110

Each

46.0000

1

2

EF 10/09/20

Nuts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	46	
112453	46	

NAS509L12C



Purchased

No

110

Each

51.0000

1

2

EF 10/09/20

Nuts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	51	
112314	41	
112828	10	

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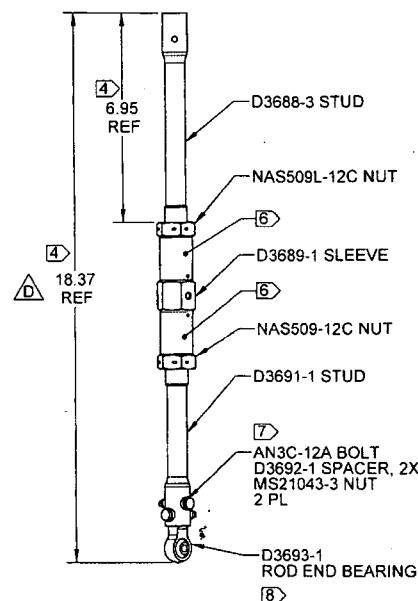
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT

HF 62165



D3684-049 AFT LEG ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.86 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. D	
MFG. APPR.		DRAWING NO. D3684 SHEET 5 OF 5	
APPROVED		TITLE	
DE APPR.		SCALE	
DATE 10.03.03		NTS	
TRIPOD MOUNT ASSY			

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